Work Order ID 100114 April-18-13 9:26:11 AM

100114

Item ID: Revision ID: Item Name:	646.3511 Strut		,	Accept	*N900	040	100)* ፡	Setup Sta Sto	IVI	S1* S2*
Start Date: Required Date: Reference:		t Qty: 10.00 d Qty: 10.00	*10* *10*		Cust Item 1 Customer:	ID:				;	5 /
Approvals:	Process Plan: QC:		Date: 13-04-18			ate:			Run Sta	1/1	R1* R2*
Sequence ID/ Work Center II	Oper D Descr	ation iption	•	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision N	br			. •						
646.3500	N/C		· 								
110				0.00		**					
110 Waterjet		Memo		0.00				_/&	_0_		Jm13-19-19
FLOW CNC Waterje	et S		00 plate 2.75"x 1.50" as po					10	O	·	JM13-4-27
		2-Deburr if n	ecessary				•	•			
120	QC2- I	nspect parts off ma	chine FAI/FAIB	0.00							
120 QC		Memo		0.00				_12			Jm13-4-19
Quality Control		Memo		••••				10	D		JM13-4-27
	,										PTO

NCR:	Yes	/	No

WORK ORDER NON-CONFORMANCE / UPDATE

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~ 1		ΛV	10.	19	2	

									QA Closed:	Date:	17/5/15	
Work Order:	10	011	<u></u>		DISPOSITION			AGAINST DE	PARTMENT/	PROCESS		
Part No.	64	6.	351		Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. ee/Packaging Supplier	Engineering Quality Other	
Root				Descri	otion of work order update	Initial	Act	tion	Sign &			
Cause	Date	Step	Qty	C	or Non-conformance	Chief En	g Desci	ription	Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training	Miles	140	10	Due to when Alum.	o tubing cracking Forming tend of tube Apical authoriz tube Stainloss Stee	0AS 16 12/04/2	Scrap 10	plates to ich E-maill	13.04.25	0AS 16, 2.50 13/04/25	16 16 © 13/04/29	
Unapproved	<u> </u>	<u> </u>	1	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	TO TO THE FA	AULT CAT	EGORY	195	 			
Landing	Gear			<u>X</u>	General		X	1101	<u> </u>			
<u> </u>	Bending Centre No Cracks	ot Conce	ntric to	o/s	Bend BOM/Route Broken/Damaged	Grain Hardv Inspec	/ -X1		Ovalized Over/Under Part Incorre		Pressure/Forced Temperature/Cure Weld	
	Crushed/ Cuffs	Crimped.			Burrs Contamination	———	ctions Incomplete/I tenance	Linclear	Part Lost/Missing Wrong Stock Pulled Part Moved			
<u> </u>	Heat Trea	nt		}	Countersink	Mislal			Positioned V	Vrong		
-	Inspection		Tube		Cut Too Short	Misre			Power Loss/		Other	
	Ripples in				Drill Holes	Offset	[
	Torque W		extrusion	n	Drawing	Out o	f Calibration					
	Turning S	equence			Finish	Out o	f Sequence					
	Wave/Tw	ist in Tul	oe		Folio	Outsi	de Dimensions				·	

Work Order ID 100114

April-18-13 9:26:11 AM

Quality Control

100114

Item ID: 646.3511 Accept *N900040100* Setup Start **Revision ID:** Item Name: Strut **Start Date:** 4/18/13 **Start Qty: 10.00** *10* Cust Item ID: Required Date: 4/25/13 Req'd Qty: 10.00 **Customer:** Reference: Run Process Plan: Date: **Approvals:** Tooling: Date: QC: _____ Date: ____ SPC (Y/N): Date:___ Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 130 QC8- Inspect parts - second check 0.00 *130* QC 0.00 Memo · Quality Control 10 77-429 140 0.00 *140* Small Fab 0.00Memo Small Fab 1- Fabricate tube as per dwg 150 QC5- Inspect part completeness to step on W/O *150* Memo

NCR:	Yes /	' No

NCR: Y	'es	/ No				WORK ORDER NON-	·COI	NFORM	MANCE / UP	DATE		_	.39
				· · · · · · · · · · · · · · · · · · ·							QA Closed:	Date:	
Nork Orde	· ·					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
WOIK OIGE	-					Rework	٦ .	:	Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	JO.					Scrap	1		Machining	Small Fab	Prod	d. Eng. Coor.	Quality
,	-	***				Use-as-is	1		noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	lo.					Work Order Update			Large Fab	Composite]	Supplier	
								Ĺ			T		
Root	ļ					iption of work order update	- 1	Initial		ction	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Cr	ief Eng	Desc	cription	Date	Verification	QC Inspector
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Landi	ng G	iear				General							
Larian	<u> </u>	Bending			Г	Bend		Grain			Ovalized		Pressure/Forced
	\vdash		ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
Centre Not Concentric to O/S BOM/Route Cracks Broken/Damaged								Inspecti	on incomplete		Part Incorre	ct	Weld
Crushed/Crimped. Burrs								Instruct	ions Incomplete	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs	•			Contamination		Mainte	nance		Part Moved		_	
		Heat Trea	it			Countersink		Mislabe	led		Positioned V	Vrong	_
	—	Inspection		Tube		Cut Too Short		Misread	i		Power Loss/	Surge	Other
	-	Ripples in	-			Drill Holes	Offset						
	П	Torque W		xtrusio	n	Drawing		Out of 0	Calibration				
	П	Turning S				Finish		Out of 9	Sequence				
	-	Maye/Tw				Folio		Outside	Dimensions				

(P) B-05-05

Work Order ID 100114

April-18-13 9:26:11 AM

120

Quality Control

100114

Item ID: 646.3511 Accept *N900040100* Setup Start **Revision ID:** Item Name: Strut **Start Date:** 4/18/13 **Start Qty: 10.00** *10* Cust Item ID: Required Date: 4/25/13 Req'd Qty: 10.00 **Customer:** Reference: Run Approvals: **Process Plan:** Date: Tooling: Date:_____ Date: ____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 160 Weld per dwg A/R Adminum rod Batch: 10.00 *160* EZ 13-5-7 Large Fab 0.00 Memo Large Fab Weld tube to plate as per dwg. Weld end were tube is punch. 170 QC9- Inspect visual per QSI004- Fusion Welds 0.00 *170* (D) B.05.05 QC 0.00 Memo Quality Control 180 QC5- Inspect part completeness to step on W/O 0.00

0.00

Memo

										DQA:	Date	
NCR: Y	es / No				WORK ORDER NON-C	CON	NFORI\	MANCE / UPDATE		QA Closed:	Date	
· · · · · · · · · · · · · · · · · · ·		 					-	Care Control Control		QA Closed:	Date	
NA (a. ml. O mala					DISPOSITION			AGAINS	T DE	PARTMENT,	/PROCESS	
Work Orde	:r				Rework	1		Skid-tube Crosstub	еГ		Water Jet	Engineering
Part N	lo.				Scrap	1		Machining Small Fa	-	Pro	d. Eng. Coor.	Quality
					Use-as-is		Therm	oforming Finishin	g	Rec/Stor	re/Packaging	Other
NCR N	lo				Work Order Update]		Large Fab Composit	e		Supplier	
Root				Descri	ption of work order update	1	nitial	Action		Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling					•							
Operator												
Material]						•				
Setup				5								
Other												
Process												
Supplier ·		1										
Training												
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*5 ·	Bending				Bend		Grain		<u> </u>	Ovalized		Pressure/Forced
	Centre N	lot Conce	ntric to	o/s	BOM/Route		Hardwa	re	_	Over/Under	tolerance	Temperature/Cure
i	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed	/Crimped	-		Burrs		Instruct	ions Incomplete/Unclear	L	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		
i,* .	, Heat Tre	at			Countersink		Mislabe	led		Positioned \	Wrong	
	Inspection	on Strip in	Tube		Cut Too Short	Misread			Power Loss/	'Surge	Other	
	Ripples i	n Bend		Ì	Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 100114

April-18-13 9:26:11 AM

Required Date: 4/25/13

100114

Item 1D:

646.3511

Accept

N900040100

Setup Start

Revision ID: Item Name:

Start Date:

Strut

4/18/13

Start Qty: 10.00 Req'd Qty: 10.00

10

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____ Date: ____ Tooling:

Run

_____ Date: Date: ____ SPC (Y/N): Date: ____ Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description Run Hours Qty Code Qty Number Stamp 190 Outsource process Anodize per QS1017 4.1.10.1 Memo Outsource process - Anodize Issue P/O: Anodize per dwg 200 ve & Inspect or Damage & Mat'l Certs 0.00'QC5- Inspect part completeness to step on WO 0.00 Memo

Quality Control

												DQA:	Da	te:	· ·
NCR:	Yes	/ No				WORK ORDER NON-	cor	VFOR	MANCE / UP	DATE		•		•	Ŋ
14011.		,							•			QA Closed:	Da	te:	
						DISPOSITION				AGAINST D)Ef	PARTMENT	PROCESS		
Work Ord	er:					Rework	7		Skid-tube	Crosstube	\neg		Water Jet	\Box	Engineering
Down 1						Scrap	4	I .	Machining	Small Fab	ㅓ	Pro	d. Eng. Coor.	Н	Quality
Part I	NO.					Use-as-is	-	l .	noforming	Finishing	\dashv		e/Packaging	H	Other
NCR I	No.					Work Order Update	-	(116111	Large Fab	Composite	\dashv	1100,5001	Supplier		
INCIVI	10.					Work order opadie	. [zaige i az				, ,		
Root			Ι		Descri	iption of work order update	П	Initial	Ac	tion		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
Doc/Data															
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Landi	ng (Gear				General	_	,	•	_		٦			1 .
		Bending			L	Bend		Grain				Ovalized	•	<u></u>	Pressure/Forced
	L	Centre N	ot Conce	ntric to	o/s	BOM/Route	_	Hardwa	ire	-	_	Over/Under		<u></u>	Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete	L		Part Incorre		\vdash	Weld
		Crushed/	Crimped.			Burrs	Instructions Incomplete/Unclear				Part Lost/Missing			Wrong Stock Pulled	

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Part Moved

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Work Order ID 100114

April-18-13 9:26:11 AM

Packaging

100114

Item ID: 646.3511 Accept *N900040100* Setup Start **Revision ID:** Item Name: Strut Start Date: 4/18/13 **Start Qty: 10.00** *10* **Cust Item ID:** Required Date: 4/25/13 Req'd Qty: 10.00 **Customer:** Reference: Run Process Plan: Date: Tooling: Approvals: Date: Date: _____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Number Stamp Qty 220 0.00 *220* SprayPaint 0.00 Memo **Spray Painting** Prime as per dwg (see note 3) Batch: 1252 43 230 QC14- Inspect Spray Paint 0.00 QC 0.00 Memo Quality Control 240 0.00 *240* Packaging 0.00 Memo

***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND

REV***

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE

											QA Closed:	Date	
Work Orde	or·					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part f	No					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root		·	i		Descri	ption of work order update	- 1	nitial	İ	ction	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training													
Unapproved	1_1.		<u> </u>	L			FAUL	T CATE	GORY		<u> </u>	1	
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		Bending Centre No Cracks Crushed/			o/s	Bend BOM/Route Broken/Damaged Burrs		4 `	ion Incomplete tions Incomplete	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved	issing	Pressure/Forced Temperature/Cure, Weld Wrong Stock Pulled
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	-	Torque W		vtrusia	, . 	Drawing	-	-∤	Calibration				
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	-	Nave/Tw			-	Folio		1	Dimensions				

Work Order ID 100114 A TOTAL TOTAL

April-18-13 9:26:11 AM

Required Date: 4/25/13

100114

Item ID:

646.3511

Accept

N900040100

Setup Start

Item Name: **Start Date:**

Revision ID:

Strut

4/18/13

Start Qty: 10.00 Req'd Qty: 10.00

10

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: Date: Tooling:

Date:

Run

Date: _____ SPC (Y/N):

Date:

Sequence ID/ **Work Center ID** Operation Description

Set Up/ **Run Hours** Tool ID

Tool # Plan Accept

Reject

Reject Number

250

250 QC

Memo

QC21- Final Inspection - Work Order Release

0.00

Code Qty Qty

Insp. Stamp

Quality Control

0.00

WF 13-5-13

									DQA:	Date:	`
NCR: Y	'es / No				WORK ORDER NON-	CON	FORM	MANCE / UPDATE	QA Closed:	Date:	">
			. · · · · · · · · · · · · · · · · · · ·		DISPOSITION		-	AGAINST DI	PARTMENT		
Work Orde					Rework Scrap Use-as-is		f Therm	Skid-tube Crosstube Machining Small Fab noforming Finishing	Pro	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	10				Work Order Update]		Large Fab Composite		Supplier	
Root				Descri	ption of work order update	In	nitial	Action	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Description	Date	Verification	QC Inspector.
Doc/Data											••
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Unapproved			<u> </u>			<u> </u>					
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Landi	ng Gear				General			<u></u>	٦		7
	Bending			ļ	Bend		Grain	<u> </u>	Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	 	Over/Under	 	Temperature/Cure
Cracks					Broken/Damaged				Part Incorrect		Weld
Crushed/Crimped.					Burrs			ions Incomplete/Unclear	Part Lost/M		Wrong Stock Pulled
	Cuffs			<u> </u>	Contamination	\vdash	Mainte	 	Part Moved		
	Heat Tre	at		- 1	Countersink	1 1	Mislabe	led	Positioned \	Nrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Cut Too Short

Drill Holes

Drawing

Finish Folio

Other

Power Loss/Surge

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

. Picklist Print

⊶ April-18-13 9:26:14 AM

Work Order ID: 100114

646.3511

Parent Item Name: Strut

100114 *646 3511*

Start Date: 4/18/13

Required Date: 4/25/13

Start Qty: 10.00

Required Qty: 10.00

Comments:

Parent Item:

IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM

		-		00 ,	DICI JUNI									
	Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
	M6061T6S.063		Purchased	No				sf	220.8625		0 .2926 32			
	MAOA1TA	is na?								**	0.5		J	m13-4-19
	M3045	.0 6 3":	thick		Location		Loc Q	<u>)ty</u>	Loc Code			-5	Ji	MB-4-19 MB-4-27
24	1		1		MAT021	123135	220.8			_				
)					124003	120.50 10	00.3		13	24603			
	M6061T6T0.500W.065	TO 5001	Purchased	No		15		f	131.8500	12	8.771379			
	M6061T6 6061T6 RD TUBE .500 X .0	10 500)	N H65							**		FF	13-0	29-29
	M304 TC	50046	WQ		Location		Loc Q	<u>tty</u>	Loc Code					1
	775077		*** **		MAT014		131	.85						
						112083	131	.85						

As par attach E-mai)

1 x 120633 10" 84)
9 x 117598 10"

											DQA:	Date	e:
NCR:	⁄es	/ No				WORK ORDER NON-C	O	NFORN	MANCE / UPDATE		QA Closed:	Date	∵ e:
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Work Orde Part N	•					Rework Scrap			}	osstube nall Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	•					Use-as-is Work Order Update			~ <u></u>	nishing nposite	Rec/Sto	re/Packaging Supplier	Other
Root						ption of work order update	1	Initial	Action		Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Description	l	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved					-				,		(CV)		
	<u> </u>	L	I	1		F	AUI	T CATE	GORY		<u> </u>		
Landi		3				General	_)		
		Bending Centre No Cracks Crushed/ Cuffs			o/s	Bend BOM/Route Broken/Damaged Burrs Contamination		4 '	on Incomplete ions Incomplete/Unclea	r	Ovalized Over/Under Part Incorre Part Lost/M Part Moved	ct issing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	-	Heat Trea				Countersink	Mislabeled				Positioned \		Other
	_	Inspectio Ripples in		Tube	-	Cut Too Short Drill Holes	\vdash	Misread Offset	1	L_	Power Loss,	ourge [Jouren

Out of Calibration

Out of Sequence

Outside Dimensions

Drawing

Finish

Folio

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

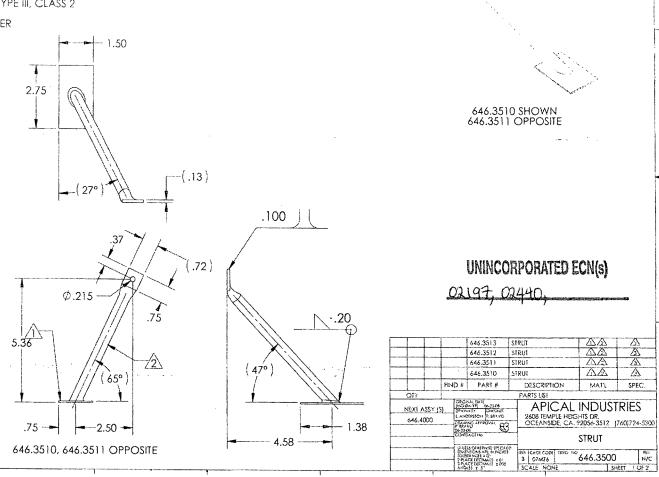
• , ~	The state of the s	ENGINEERING CHANG	E NOTIC	NO.	02440	SHEET	
	APICAL	DWG NO. 646.3500	REVINC	PREPARED S	. HUFF / DAT	· •	ECT ON DWG VC. 🛛 UNINC.
	INDUSTRIES, INC.	DWG TITLE:		STRUT	2 / / /	(I_{Ω}, Ω)	
		APPROVED BYI ENGR ASiam	MFG	1/24	P QC	EFF: CURRENT OF	DER AND STOCK
	TRANSACTION CODES (TC) A-ADD C-CREATE R-REVISE D-DELETE	REASON: REVISED GEOMET	RY TO ACC	PHODATE NE	W EXISTING AIRC	RAFT PROVISIONS	
	SHEET 2 IS:	548					
		13					
						646.3512 SHOWN 646.3513 OPPOSITE	
		72 R 650		<i>(</i>			
-	(8 25).	7.60		58,		Forth COP The Cop COP The Cop Cop Cop Cop Cop Cop Cop Cop Cop Cop	
		.100	200	0	20	100115 M	
		4 90		200	2.37	1300	1 10
	DECLINICATE SCALE				OHANGE OATEGON	T 250 251 (551 (250)) — D
	DOCUMENTS EFFECTED:	☐ MDL ☐ INSTALL INSTRUC	: □ ICA □	FMS 🗆 BOM	CHANGE CATEGORY D MAJOR 🛭 MINOR	DER REVIEW REQUIR	くFル

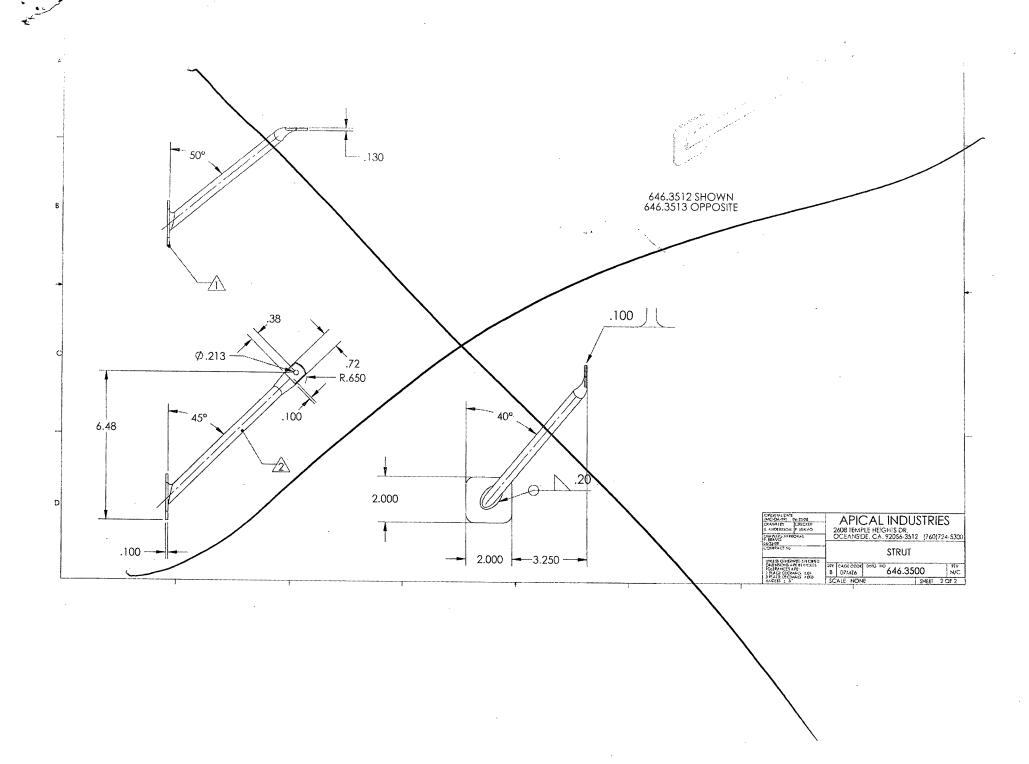
**

NOTES:

- 1: MATERIAL: 6061-T6 ALUMINUM IAW AMS-QQ-A-250/11; .062" THK.
- FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2 COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377J TYPE I CLASS N
- 4. DEBURR AND BREAK ALL SHARP EDGES
- 5. WELDS IAW MIL-STD-2219. TIG WELD WITH FILLER ROD

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DART AEROSPACE LTD	Work Order:	9. 100114	
Description: Strut	Part Number:	646.3511	
Inspection Dwg: 646. 3500 Rev: 10/c		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
	1,50"	41-0.010	1.5034	v		ν	JAMOT
	2.75"	11-0.010	2.756"	7		V	
!	6.063	41-0.010	0.060"			V	
Recut	1,50"	# 0.00	1.498"	~		V	Jknoi
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Measured by: Jm Audited by: Preliminary Approval:

Date: 3-4-19 Date: 13-4-19 Date:

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 Change
 15 431
 Revised by
 Approved

 E
 10.04.14
 Added preliminary approval
 KJ

\$ 10.04.15